

Date: Monday, 11/12/2007 11:46:24 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING	
Job Number	: 35628		Part Number	: D2618	
Estimate Number	: 10897		Drawing Number	: D2618 REV B1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	11/12/2007	S.O. No. : N/A	Drawing Revision	: B1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/30/2007	
Previous Run	: 35096		Qty:	300	Um: Each
Written By			248		
Checked & Approved By			248		
Comment	: Est Rev: F Re-format 05-11-22 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELRINR0750	Delrin Round Bar 0.75"
		 Comment: Qty.: 82709 f(s)/Unit Total: 81.2700 f(s) Delrin Round Bar .75" black 80.0000 (MDELRINR0500) 0.750 750 07.12.07 Batch: M105750
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		 Comment: HARDINGE CNC LATHE SMALL
		1-Turn as per Folio FA195 & Dwg D2618. 2-Deburr
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 42 overstock

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.11.05	1	Wrong Mat'l size. Change to ϕ .500" Permanent change if possible.	BS	07.11.05		07-12-04	07-12-04

Part No: 11 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/12/05
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.12.04	2	52 pcs scrap. Mat'l was warped.	BS 071042	Pants electrical rework 30xM 105x50 52 scrap No replace, is no more material	BS 07.12.04	07-12-04	07-12-04	07-12-04
				Root CAUSE: Mat'l store incorrectly				

NOTE: Date & initial all entries

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Job Number: 35628		Part Number: D2618
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE
		 248
Comment: FINAL INSPECTION/W/O RELEASE		11/12/05
Job Completion		

11/12/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35628
Description: Bushing	Part Number:	D2618
Inspection Dwg: D2618	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>J.A. Ony</u>	Audited by: <u>BG</u>	Prototype Approval:	N/A
Date: <u>07/11/30</u>	Date: <u>07.12.04</u>	Date:	N/A

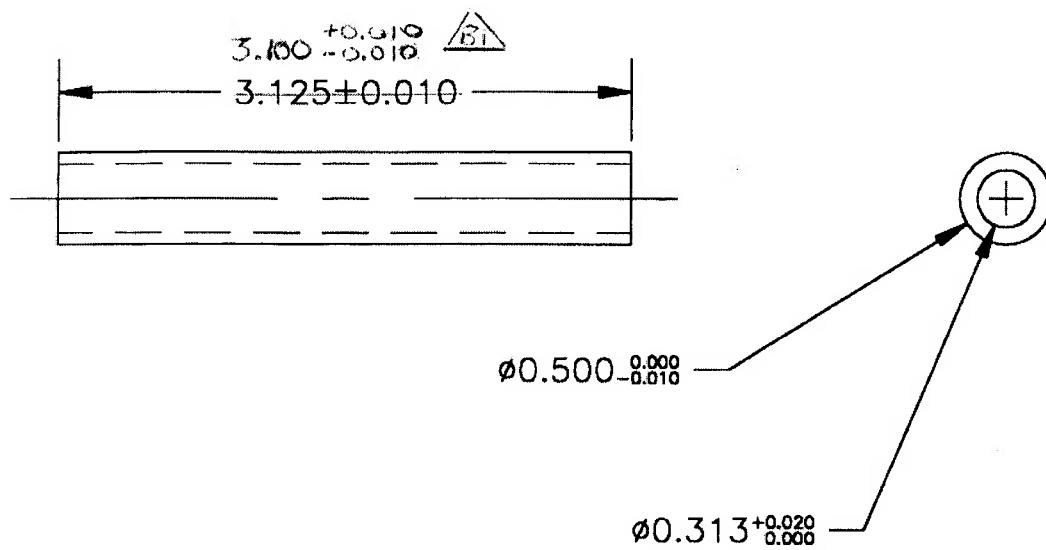
Rev	Date	Change	Revised by	Approved
A	04.08.26	New Issue	KJ/JLM	
B	04.09.10	Changed tolerance for Ø0.500	KJ/JLM	



3A COPY ISSUED
DRAFT

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2618	REV. B SHEET 1 OF 1
DATE 96:10:30		TITLE BUSHING	SCALE 1:1
B	97.05.09	3.125 WAS 1.625, .313 WAS .375	
81	4/03	CHANGE DIM FOR BETTER FIT	

RELEASED
97/05/13 DS



MATERIAL: DELRIN OR TEFLON OR NYLON

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35628